

Date: Tuesday, 19/08/2008 4:03:44 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RADIUS BLOCK		
Job Number	: 41422					
Estimate Number	: 10822					
P.O. Number	:			Part Number	: D2274	
This Issue	: 19/08/2008		S.O. No. :	Drawing Number	: D2274 REV F	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: F	
Previous Run	: 39238			Material	:	
Written By	:			Due Date	: 20/09/2008	
Checked & Approved By	<u>JUL 08/8/19</u>			Qty:	500	Um: Each
Comment	: Est. H 00.05.18 Added inspection level 8 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .750 x .125  <i>Not enough mat in comp</i> <i>1.5772 Not taken out of comp</i>
		<i>6061-T6 Bar .75" x .125"</i>
		<i>Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M107482</i>
2.0	SHEAR	SHEAR  <i>MJL 08/08/31</i>
		<i>Comment: SHEAR</i> <i>Shear blanks 9.00" long +/- 0.030"</i> <i>Note: 1 blank makes 9 pieces</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  <i>MJL 08/08/31</i>
		<i>Comment: HAAS CNC VERTICAL MACHINING #1</i> <i>Machine as per folio D2274</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <i>20 08/09/11</i>
		<i>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</i>
5.0	QC8	SECOND CHECK  <i>20 08/09/11</i>
		<i>Comment: SECOND CHECK</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

8/08/10/07 606

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



counted!

606

506x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8/08/10/07 08/10/07

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



4/

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-07 506x

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 24

AS 08/10/08 x556

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 AS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/08/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41422
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	RP	Audited by:	SD	Prototype Approval:	N/A
Date:	08/09/01	Date:	08/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	JK

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**RETURN TO**

## ENGINEERING

UNCONTROLLED COPY

**SUBJECT TO AMENDMENT**

## WITHOUT NOTICE

## WORK ORDER

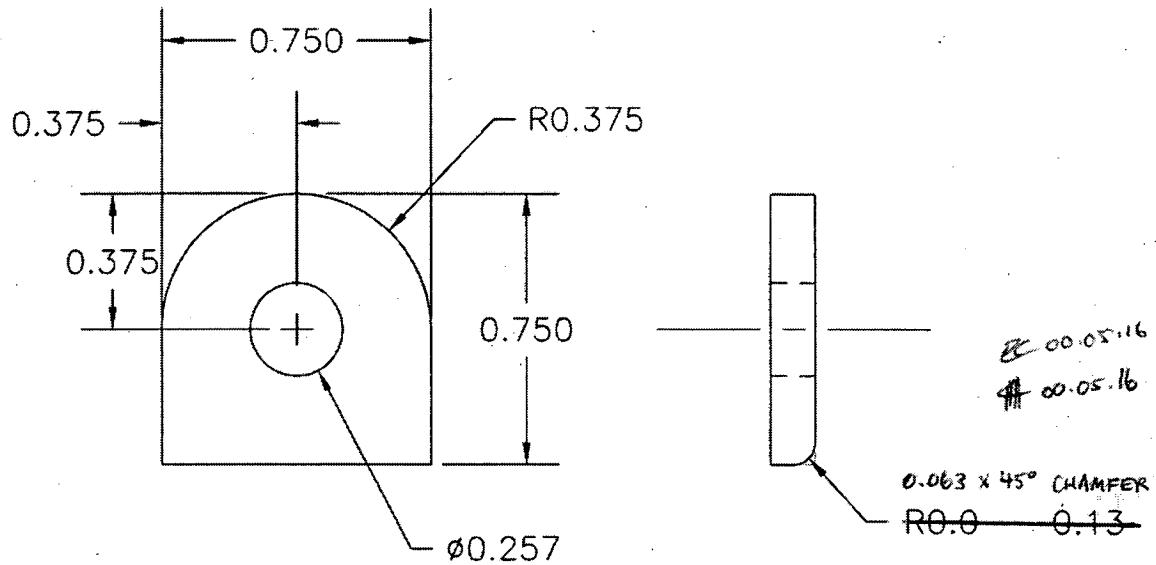
4142

THE JOURNAL OF CLIMATE



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED NO	APPROVED GS	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED  
98/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

